

# Work Order ID 68461

Wednesday, April 13, 2011 3:30:16 PM



Page 1

Item ID: D4151-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Basket Instl Stud

Start Date: 4/13/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 11-01-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	C								

110

0.00



Doosan

Memo

0.00

Doosan Lathe

1-Mill as per folio FA953 & dwg.

FOLIO REV: *AA*

DWG REV: *C*

*Handwritten: 11/4/27*

2-GRIND .13" RAD MANUALLY

3-Deburr as required

*Handwritten: 6 0*

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*Handwritten: 11/4/27*

*Handwritten: 6 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




# Work Order ID 68461

Wednesday, April 13, 2011 3:30:16 PM

Page 2

Item ID:	D4151-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fwd Basket Instl Stud					
Start Date:	4/13/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	4/20/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		H.A 11/04/27		6	0		
140  Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u>  Memo <u>W/O 068575</u>	0.00  0.00		SS 11/04/27		(6)			
150  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							11/4/27 me 11-04-27

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# Picklist Print

Wednesday, April 13, 2011 3:30:22 PM

Work Order ID: 68461

Parent Item: D4151-5

Parent Item Name: Fwd Basket Instl Stud



Start Date: 4/13/2011

Required Date: 4/13/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B  
11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued
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M303R1.000

Purchased

No

110

f

12.6070

0.25

1.578947



303 Round Bar 1.00

4/11/21

Location

Loc Qty

Loc Code

MAT028

12.607

116700

12.607

155

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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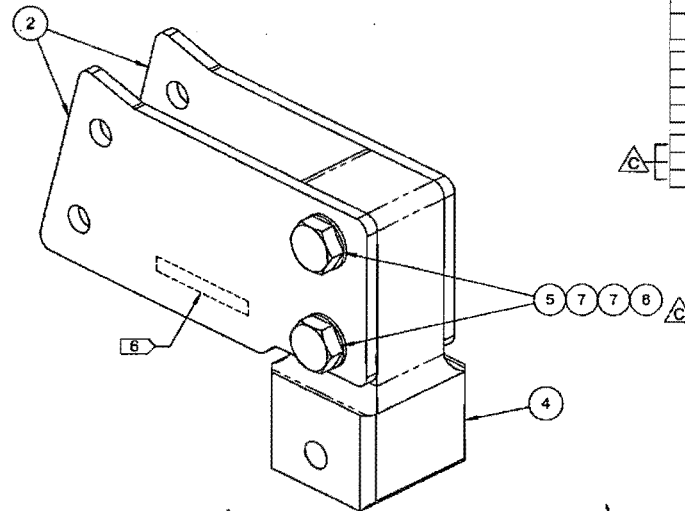
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

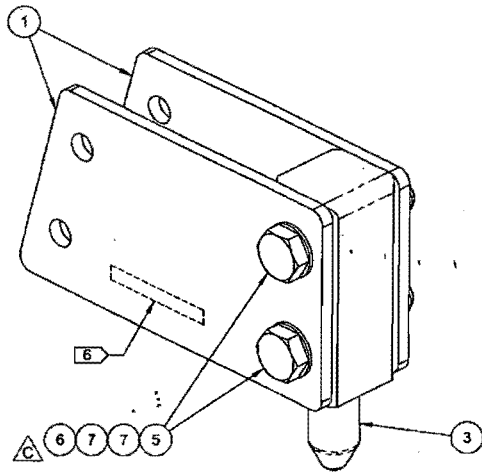
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**D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)**



**D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)**

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68464

PR11-04-13

RELEASED  
2011-01-18

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT:
    - D4151-041 = 0.88 lbs
    - D4151-043 = 1.17 lbs

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TO 1,000 INCH (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2); 2.84 WAS 2.76 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.80. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20815-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C  
SHEET 1 OF 3

TITLE **BASKET FWD HARDPOINT** SCALE NTS

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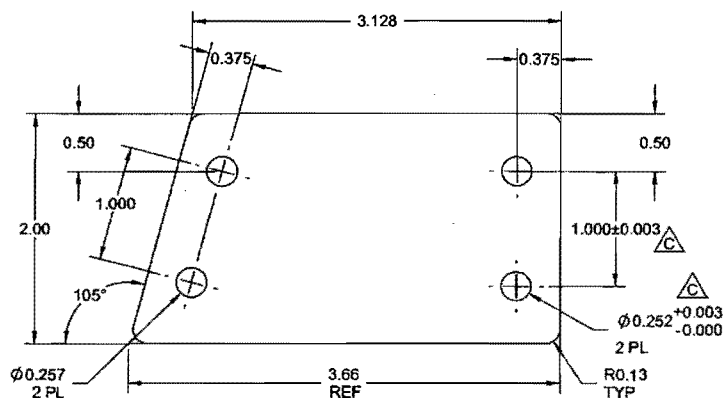
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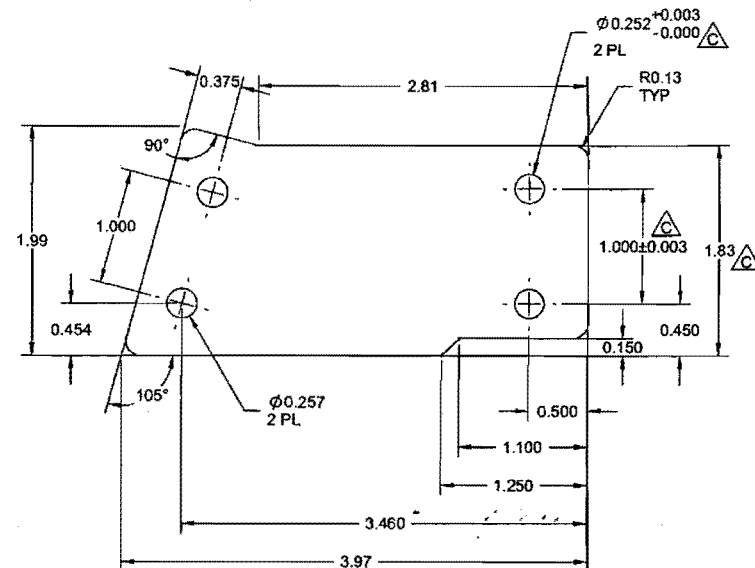
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**NOTE:** Date & initial all entries



0.125  
REF

**D4151-1 LOWER HARDPOINT PLATE**



0.125  
REF

**D4151-3 UPPER HARDPOINT PLATE**

**NOTES:**

1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S11GA OR M303S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AT ASSEMBLY

7) WEIGHT:

- D4151-1 = 0.24 lbs

- D4151-3 = 0.23 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4151</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET FWD HARDPOINT</b>	NTS
DATE	10.12.14	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
R 2011-01-18  
MP

u/o 68461

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